

*Split* *W/Jet*

*AWG*

**DART**  
AEROSPACE

Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada  
Tel (613) 632-5200

**RBE350A93-3205-00E**  
**Job Sheet 179388**

**Part No:** RBE350A93-3205-00E **Job Qty:** 40 ea

**Part Name:** Engine G/B Input Flange Holding Wrench

**Part Weight:** 0 lbs **Status:** At Planning **Priority:** Medium

**Job Created:** 6/18/18 **Job Tracking No:**

**Due Date:** 8/6/18 **Created By:** Logan David

**Type:** SOLD **Description:**

**Note:** DWG RBE350A93-3205-00E Rev 2A IPP Rev A 17.12.21 New issue DP Verify DD

**Ship Via:**

**Bill of Materials**

**Job Routing**

| Op No | Operation          | Qty    | Start Date | Due Date | Standard Setup hrs | Run Hrs | Workcenter/Supplier | Lead Time | Sign-off           |
|-------|--------------------|--------|------------|----------|--------------------|---------|---------------------|-----------|--------------------|
| 90    | Start up Operation | 10 Ea  | 8/6/18     | 8/6/18   | 0.00               | 0.00    | Start Up Waterjet   |           | <i>OK 18/07/24</i> |
| 100   | Waterjet           | 10 pcs | 8/6/18     | 8/6/18   | 0.00               | 1.00    | Waterjet 2 OMAX     |           | <i>OK 18/07/24</i> |
| 110   | QC                 | 10 pcs | 8/6/18     | 8/6/18   | 0.00               | 0.00    | QC2 Waterjet-4      |           | <i>OK 18/07/24</i> |
| 120   | Mori Seiki         | 10 pcs | 8/6/18     | 8/6/18   | 0.00               | 10.00   | MORI NV5000-2       |           |                    |
| 130   | QC                 | 10 pcs | 8/6/18     | 8/6/18   | 0.00               | 0.00    | QC2-2               |           |                    |
| 140   | QC                 | 10 pcs | 8/6/18     | 8/6/18   | 0.00               | 0.00    | QC8                 |           | <i>S. 18-09-H</i>  |
| 170   | Outsource          | 10 pcs | 8/6/18     | 8/6/18   |                    |         | GROU2-VG            | 10        |                    |
| 180   | Packaging          | 10 pcs | 8/6/18     | 8/6/18   | 0.00               | 0.00    | Packaging2          |           |                    |
| 190   | QC                 | 10 pcs | 8/6/18     | 8/6/18   | 0.00               | 0.00    | QC6                 |           | <i>Not req.</i>    |
| 191   | Small Fab          | 10 pcs | 8/6/18     | 8/6/18   | 0.00               | 2.00    | Small Fab-3         |           |                    |
| 192   | QC                 | 10 pcs | 8/6/18     | 8/6/18   | 0.00               | 0.00    | QC5                 |           |                    |
| 206   | Packaging          | 10 pcs | 8/6/18     | 8/6/18   | 0.00               | 0.00    | Packaging3-2        |           | <i>SEP 1 2018</i>  |
| 210   | QC21-FG            | 10 Ea  | 8/6/18     | 8/6/18   | 0.00               | 0.00    | QC21                |           |                    |

Part Op 100 - 1-Cut as per Dwg Dwg Rev: *2A* Prog Rev: *2A* 2-Deburr if necessary

Descriptions: 120 - 1-Machine as per folio FB743 FOLIO REV: *AA* DWG REV: *2A* 2-Deburr 3-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

170 - Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A93-3205-00E Rev. 2A

191 - Pick, bag and tag. \*\*\*See engineering for hardware sign off. WAS AN315-5, IS AN315-5R\*\*\*

206 - Bag and tag

**Job BOM**

| Part / Item   | Component Name     | Quantity     | Operation             | Container      |
|---------------|--------------------|--------------|-----------------------|----------------|
| M6061T6S.250  | 6061T6 Sheet .250  | 4 sf (.4 ea) | 90-Start up Operation | <i>5090359</i> |
| AN315-5R      | Nut 5/16-24        | 30 Ea (3 ea) | 191-Small Fab         | <i>5036413</i> |
| AN5-7         | Hex Head Cap Screw | 30 Ea (3 ea) | 191-Small Fab         | <i>5036413</i> |
| NAS1149F0563P | Washer             | 30 Ea (3 ea) | 191-Small Fab         | <i>5067901</i> |

**Job Allocations**

| Operation             | Component Part | Required | Inventory     | Allocated |
|-----------------------|----------------|----------|---------------|-----------|
| 90-Start up Operation | M6061T6S.250   | 4        | <i>64 25</i>  | 0         |
| 191-Small Fab         | AN315-5R       | 30       | <i>27 24</i>  | 0         |
|                       | AN5-7          | 30       | <i>230 54</i> | 0         |
|                       | NAS1149F0563P  | 30       | <i>54 646</i> | 0         |

*54 - 30 = "24"*

*418*

Plex 6/18/18 2:20 PM dart.logan.david



Container No: S096004

Part: RBE350A93-3205-00E

Job No: 179388

Serial No/Batch: S096004

Revision: 2A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 07/25/16

**Part Specifications**

Specifications could not be found.

Plex 6/18/18 2:20 PM dart.logan.david





DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

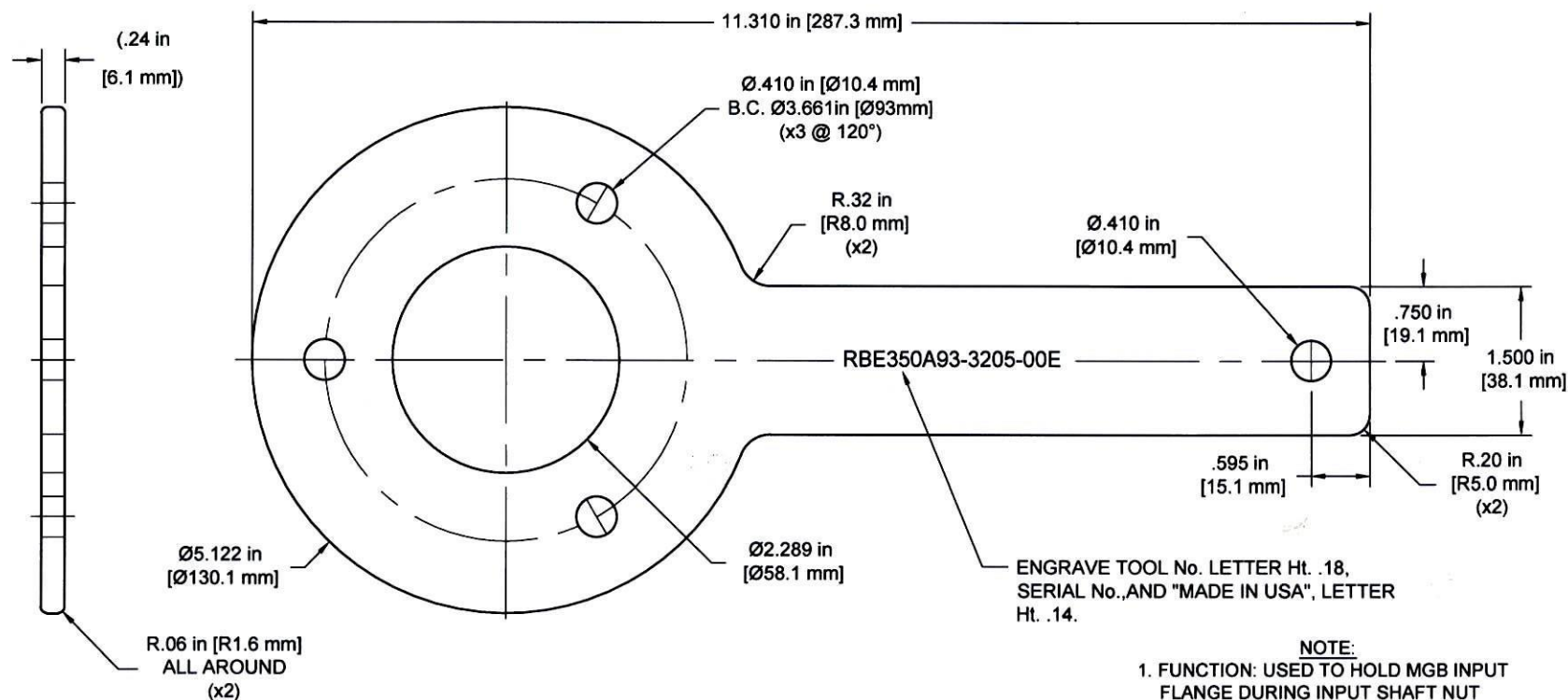
Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube <input type="checkbox"/></td> <td style="width: 15%;">Cross tube <input type="checkbox"/></td> <td style="width: 15%;">Water Jet <input type="checkbox"/></td> <td style="width: 15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>                                                                                                                                                                                                                                                                                                                               |  |                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  | Skid-tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                       | Cross tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                               | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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| <b>Root Cause</b><br><table style="width: 100%; border: none;"> <tr> <td style="width: 50%;">           Environment <input type="checkbox"/><br/>           Design <input type="checkbox"/><br/>           Doc/Data <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Pre <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Internal Transport <input type="checkbox"/><br/>           Tribal Knowledge <input type="checkbox"/><br/>           LOA <input type="checkbox"/><br/>           Substation <input type="checkbox"/><br/>           Past Expiry Date <input type="checkbox"/><br/>           Misidentified <input type="checkbox"/> </td> <td style="width: 50%;">           No Re-verification <input type="checkbox"/><br/>           Operator <input type="checkbox"/><br/>           Offset/Setup <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Training <input type="checkbox"/><br/>           Use for Testing <input type="checkbox"/><br/>           Poor Information <input type="checkbox"/><br/>           Rushing <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Past Due <input type="checkbox"/> </td> </tr> </table> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/> | No Re-verification <input type="checkbox"/><br>Operator <input type="checkbox"/><br>Offset/Setup <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> | <table style="width: 100%; border: none;"> <tr> <td style="width: 50%;">           Pressure/Forced <input type="checkbox"/><br/>           Bending <input type="checkbox"/><br/>           Centre Not Concentric <input type="checkbox"/><br/>           Cracks <input type="checkbox"/><br/>           Crimp/Kink/Ripple/Wave <input type="checkbox"/><br/>           Cuffs <input type="checkbox"/><br/>           Crushing <input type="checkbox"/><br/>           Heat Treat <input type="checkbox"/><br/>           Wave/Twist in Tube <input type="checkbox"/><br/>           Marks/Chatter <input type="checkbox"/> </td> <td style="width: 50%;">           Temperature/Cure <input type="checkbox"/><br/>           Set-up <input type="checkbox"/><br/>           BOM/Route <input type="checkbox"/><br/>           Broken/Damage/Defect <input type="checkbox"/><br/>           Inspection Incomplete/Unqualified <input type="checkbox"/><br/>           Contamination <input type="checkbox"/><br/>           Countersink <input type="checkbox"/><br/>           Cut Too Short <input type="checkbox"/><br/>           Instructions Incomplete/Unclear <input type="checkbox"/><br/>           Drill Holes <input type="checkbox"/> </td> </tr> </table> |  | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not Concentric <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/><br>Set-up <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> | <b>FAULT CATEGORY</b><br><table style="width: 100%; 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| OTHER : <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| REVISIONS |                                                                                                                           |          |                    |
|-----------|---------------------------------------------------------------------------------------------------------------------------|----------|--------------------|
| REV       | DESCRIPTION                                                                                                               | DATE     | INITIAL / APPROVED |
| 1         | PER HELI PRODUCTS TOOLS.                                                                                                  | 10/22/09 | WP DW              |
| 2         | CH'D HOLE DIAMETER FROM .402 TO .410, ADDED MISSING R.063 DIM. PER G.E.                                                   | 9/15/11  | RJC RW             |
| 2A        | CORRECTED T/N WAS RBEA93-3205-00E IS RBE350A93-3205-00E. CH'D DIMENSION PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS. | 11/5/13  | RJC RW             |



NOTE:  
1. FUNCTION: USED TO HOLD MGB INPUT FLANGE DURING INPUT SHAFT NUT REMOVAL OPERATION.

|                                                                                                                                                                                |                |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| <b>RED BARN MACHINE</b>                                                                                                                                                        |                |
| TITLE ENGINE GEAR BOX INPUT FLANGE HOLDING WRENCH                                                                                                                              |                |
| DWG NO. RBE350A93-3205-00E                                                                                                                                                     | REV 2A         |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES                                                                                                                            |                |
| TOLERANCES ON:<br>DECIMALS .XXX ± .005<br>.XX ± .01<br>.X ± .1                                                                                                                 |                |
| FRACTIONS ± 1/32<br>ANGLES ± 5°                                                                                                                                                |                |
| UNLESS OTHERWISE SPECIFIED<br>1. BREAK ALL SHARP EDGES<br>.015 x 45° PR .015 R<br>2. DIMENSIONAL LIMITS APPLY AFTER PLATING                                                    |                |
| DRAWN BY: PERRITT<br>APPROVED: <i>D. Pitt</i><br>HEAT TREAT: ANODIZE RED<br>FINISH: ANODIZE RED<br>SPEC: MIL-A-8625F, TYPE II, CLASS II<br>USED ON MODEL: EUROCOPTER AS350/355 |                |
| SCALE: NTS                                                                                                                                                                     | DATE: 10-22-08 |
| SHEET 1 of 1                                                                                                                                                                   |                |

| ASSY QTY | ASSY QTY | B/O | PART # | UNIT QTY | DESCRIPTION        | MATERIAL | B/O INFORMATION OR SPECIFICATIONS          |
|----------|----------|-----|--------|----------|--------------------|----------|--------------------------------------------|
|          |          |     | 1      |          | ENGINE WRENCH      | 6061     | 1/4 x 5-1/4 x 11-1/2                       |
|          |          | B/O | 3      |          | HEX HEAD CAP SCREW | STEEL    | 5/16-24 UNF x 31/32 AIRCRAFT SPRUCE #AN5-7 |
|          |          | B/O | 3      |          | NUT                | STEEL    | 5/16-24 UNF AIRCRAFT SPRUCE #AN315-5       |
|          |          | B/O | 3      |          | FLAT WASHER        | STEEL    | Ø5/16 I.D. AIRCRAFT SPRUCE #AN960-516      |
| ASSY #   |          |     |        |          |                    |          |                                            |